



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PRELIMINARY ISSUE

D5484-1

Job Sheet 167351



Part No: D5484-1

Job Qty: 30 ea

Part Name: Aft Cap



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/30/17

Job Tracking No:

Due Date: 11/6/17

Created By: Diane Baker

Type: Stock

Description:

Ship Via:

5020767

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	11/6/17	11/6/17	0.00	0.00	Start-up container		
100	Purchasing	30 pcs	11/6/17	11/6/17	0.00	0.00	Purchasing		<i>Chad</i>
110	Packaging	30 pcs	11/6/17	11/6/17	0.00	0.00	Packaging2		<i>Chad 12-12DA3</i>
120	QC	30 pcs	11/6/17	11/6/17	0.00	0.00	QC6		<i>58 FEB 07 2019 68</i>
130	Packaging	30 pcs	11/6/17	11/6/17	0.00	0.00	Packaging3 <i>DAB 21</i>		<i>58 FEB 07 2019 89</i>
140	QC21-SA	30 Ea	11/6/17	11/6/17	0.00	0.00	QC21		<i>9-8 FEB 07 2019</i>

Part Op 100 - Issue P/O: *038193* Manufacture D5484 as per dwg. Supplier: Metellurgie Cyca Inc. Material release
Descriptions: note required *Gamma*

110 - Ensure Material Release Note is attached

OCT 30 2017 UNB

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D5484-1P	30	0	0	0

Part Specifications

Specifications could not be found.

Plex 10/30/17 10:00 AM dart.baker.diane

POSITIVE RECALL

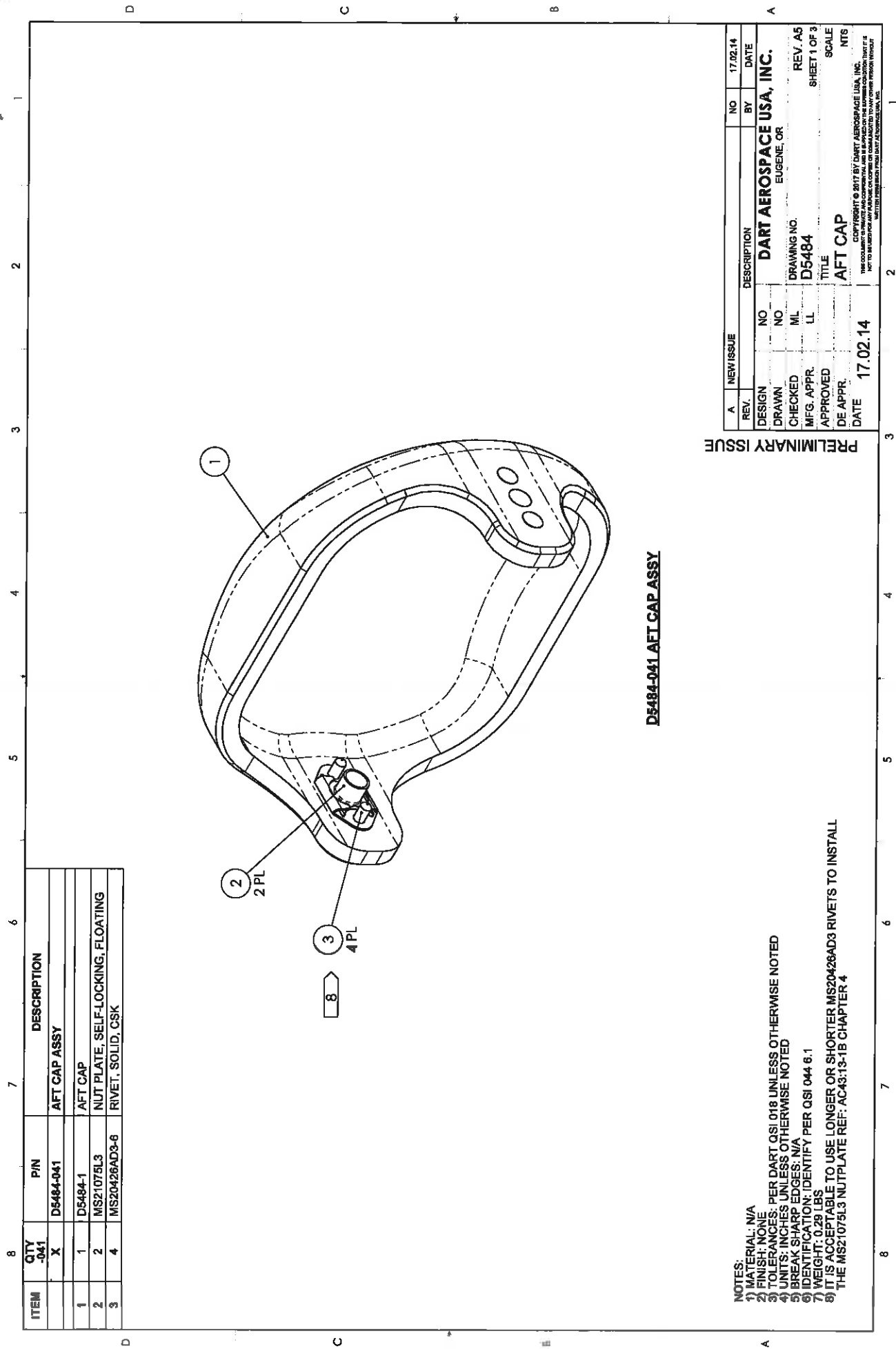
EFFECTIVE *OCT 31 2017*

RELEASED *RD*

AUTH: *UNB*
DATE: *19-02-06*

RD 17-74201
@ Rev A
per ECHN-724

P.T.O.





PRELIMINARY ISSUE

DESIGN	NO	DART AEROSPACE USA, INC.
DRAWN	NO	EUGENE, OR
CHECKED	ML	REV. A5
MFG. APPR.	LL	SHEET 2 OF 3
APPROVED		SCALE
DE APPR.		NTS
DATE	17.02.14	TITLE
		AFT CAP
		DRAWING NO. D5484

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- PRELIMINARY ISSUE

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MFG. APPR.	LL	D5484	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DES. APPR.		AFT CAP	NTS
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Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038193

Supplier: GAM001-VC
Gamma Foundries Inc.
115 Newkirk Road,
Richmond Hill
ON
L4C 3G4 Canada
Phone: 905-884-9091
Fax: 905-780-9572

PO No: PO038193
PO Date: 10/30/17
Due Date: 11/6/17
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
10/30/17

Ship To:

Items													
Line Item	Part	Rev	Supplier Part No	Item No	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D5483-1P	-			Fwd Cap As per Dwg D5483 Rev. A7		Firmed	11/6/17	30 pcs	0 pcs	30 pcs	\$71.98/pcs	\$2,159.40
Line Item Note job # 167349 30 pcs. @ 48.65 plus \$700.00 Foundry Tooling													
2	D5484-1P	-			Aft Cap As per Dwg D5484 Rev. A5		Firmed	11/6/17	30 pcs	0 pcs	30 pcs	\$70.80/pcs	\$2,124.00
Line Item Note job # 167349 30 pcs. @ 47.47 plus \$700.00 Foundry Tooling													
Grand Total:												\$4,283.40	

Order Notes

DWG REV A7

DWG REV A5

Procurement Quality Clauses

- A005 right of entry
- A012 chemical and physical test report
- A016 personnel qualification
- A017 raw material identification (as applicable)
- A026 certification of material conformance
- A041 quality management system
- A042 dart notification by supplier
- A043 retention of quality documents

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/30/17 10:23 AM dart.baker.diane

FRT: COLLECT

Packing Slip

VIA: FEDEX

CUSTOMER ORDER NO./NUMÉRO DE COMM. DU CLIENT
38193ORDER NO./N° DE COMM.
721166DATE
2-Nov-2017

GAMMA FOUNDRIES INC
115 NEWKIRK ROAD
RICHMOND HILL, ONTARIO
L4C 3G4
TEL.: (905) 884-9091
FAX: (905) 780-9572

F.O.B. / F.A.B.
GAMMA FOUNDRIES

Job:

SOLD TO / VENDU À: 83509

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON
CANADA, K6A 1K7

SHIPPED TO / EXPÉDIÉ À:

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY
ON ON K6A 1K7

ITEM NO. NO. D'ART	QTYORO/QUE QTE COMIDU	DESCRIPTION	PKG WEIGHT PAQUET POIO	QTY. ALLOCATED QTE A LOUER DE
10	30.00	EFD54831P3D TOP CAP ~ CAD5483-1P (3D) CUSTOMER NAME - DART AEROSPACE CUSTOMER PART NR - D5483-1P DESCRIPTION - TOW CAP Alloy ID - A356.2 SPECS - B26 CASTING WGT - 0.575 LB DRW - D5483 REV. - A7		30.00
20	30.00	EFD54841P3D AFT CAP ~ CAD5484-1P (3D) CUSTOMER NAME - DART AEROSPACE CUSTOMER PART NR - D5484-1P DESCRIPTION - AFT CAP Alloy ID - A356.2 SPECS - B26 CASTING WGT - 0.290 LB DRW - D5484 REV. - A5		30.00
Order Notes: SHIP VIA FEDEX OVERNIGHT A/C#151793240				Total Weight: 29

DAS
68
9-89

CUSTOMER SIGNATURE/SIGNATURE DU CLIENT		SHIPPED VIA /EXPÉDÉ VIA: FEDEX	BAGS SACS	INTERNAL USE ONLY SHPG. PAPERS ATT./ DOCUMENTS D'EXPÉD. ATT.	
			CTNS		
DATE SHIPPED / DATE D'EXPÉDITION 8-Dec-2017		COMPLETE COMPLÉT	BOXES BOITES	ONE STEP BY	DATE
			TOTAL	TRANSPORTATION CHARGES/FRAIS DE TRANSPORT	

1 CARTON
15 X 12 X 13
29 lbs

Tel: 905-884-9091

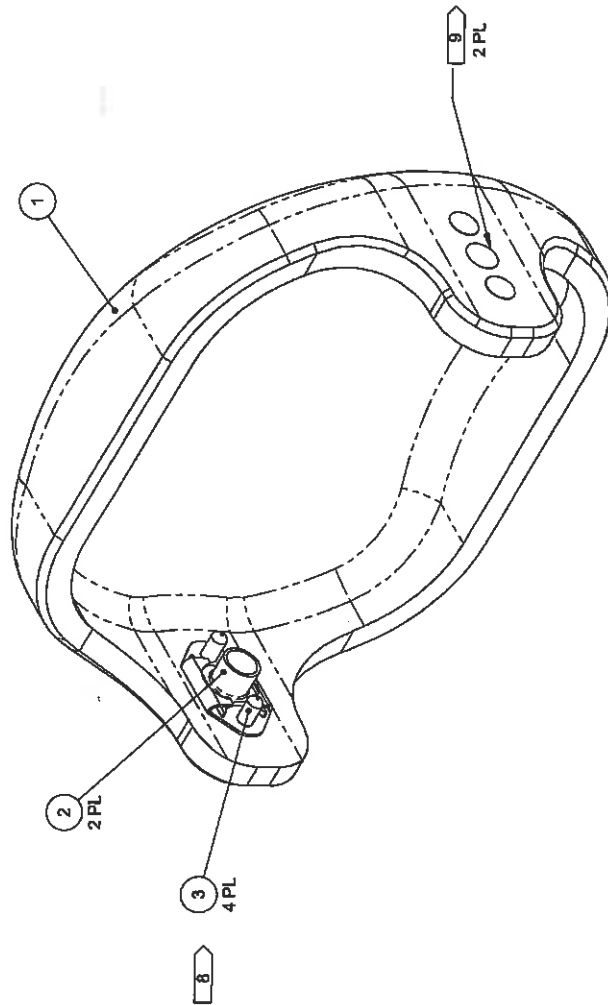
Fax: 905-884-2664

CERTIFICATE OF COMPLIANCE

We hereby certify that the above product was made per
your purchase order and the specification stated above.
This material is free of any mercury contamination.

Thomas Warren
Manager of Quality and Engineering

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5484-041	AFT CAP ASSY
1	1	D5484-1	AFT CAP
2	2	MS21075L3N	NUT PLATE, SELF-LOCKING, FLOATING
3	4	CCR264SS-3-04	RIVET, BLIND, CSK



D5484-041 AFT CAP ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE PER QSI 005.4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.29 LBS
 - 8) IT IS ACCEPTABLE TO USE LONGER OR SHORTER CCR264SS-3 RIVETS TO INSTALL THE MS21075L3N NUTPLATE REF: AC43:13-1B CHAPTER 4
 - 9) MASK PRIOR TO FINISHING

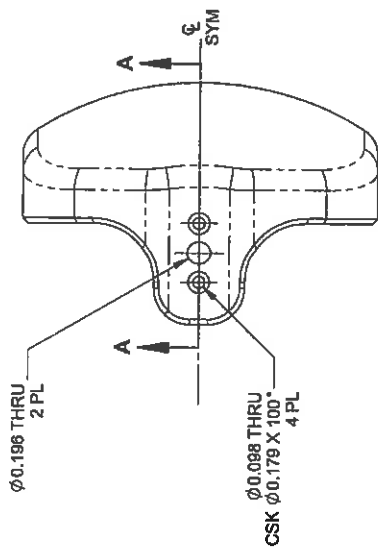
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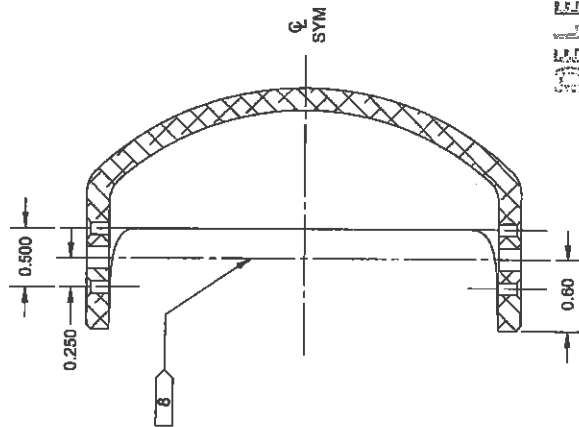
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CHECKED	NO		
MFG. APPR.	AJS		
APPROVED	JFS		
DE APPR.	WM		
DATE	17.02.14		

DART AEROSPACE USA, INC.	EUGENE, OR	REV. A
D5484	DRAWING NO.	SHEET 1 OF 3
AFT CAP	TITLE	SCALE
17.02.14	DATE	NTS

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D5484-1
(DRILLING DETAIL)



SECTION A-A

- NOTES:
- 1) MATERIAL: MAKE FROM D5484-1C
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) Ø0.196 HOLES TO BE ALIGNED WITHIN ±0.005 OF EACH OTHER AS SHOWN (2 PL)

DESIGN	NO	NO	DATE	17.02.14
DRAWN	CHECKED	NO		
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		WM		
		DS		
		DS		

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2017-10-31
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DART AEROSPACE USA, INC.
EUGENE, OR
DRAWING NO. **D5484**
REV. **A**
SHEET 2 OF 3
SCALE
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WORK ORDER NON-CONFORMANCE / UPDATE

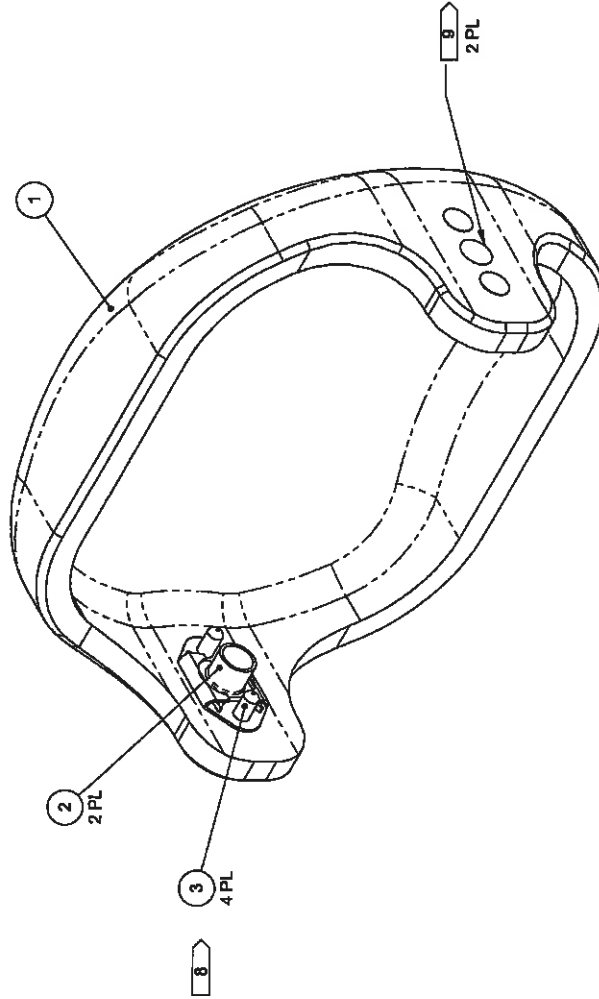
QA Closed: _____ Date: _____		Work Order update only	
Work Order: <u>16735</u>		AGAINST DEPARTMENT/PROCESS	
Part No. <u>05784-1</u>		Engineering Quality Other	
NCR No. <u>19-7198</u>		Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier	
Date: <u>18-01-11</u>		MRB (QSI042) Approval	
Step #: <u>120</u>		<u>WSP</u> <u>12</u> <u>16/1/20</u>	
Description Work Order Deviation		Disposition	
Some "key" dimension are out of tolerance see attach FAI		Acceptable. Non-structural. Verify fit before Wk. assembly.	
Also finish on casting is suff and some part found with imperfection		Completed By <u>16/1/20</u>	
		Lead hand / Supervisor Approval Verification	
		<u>PD</u> <u>19.02.06</u>	
		QC / QA Coordinator Approval	
		<u>PD</u> <u>19.02.20</u>	
Root Cause		FAULT CATEGORY	
Environment		Power Loss/Surge	
Design		Folio/Program	
Doc/Data		Grain	
Equip/Tooling		Weld	
Handling/Pre		Wrong Stock Pulled	
Material		Out of Sequence	
Internal Transport		Off-set	
Tribal Knowledge		Mislabeled	
LOA		Fit/Function	
Substation		Misaligned/off center	
Past Expiry Date		Positioned Wrong	
Misidentified		Outside Dimensions	
		Over/Under tolerance	
		Part Incorrect	
		Part Lost/Missing	
		Part Moved	
		Drawing	
		Finish	
		Misread	
		Turning Sequence	
		OTHER :	



2017-10-31
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DRAWN	NO	
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APPROVED	WM	
DE APPR.	DSC	TITLE
		AFT CAP
DATE	17.02.14	SCALE
		NTS
REV. A SHEET 3 OF 3		
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D5484-041	AFT CAP ASSY
1	1	D5484-1	AFT CAP
2	2	MS21075L3N	NUT PLATE, SELF-LOCKING, FLOATING
3	4	CCR264SS-3-04	RIVET, BLIND, CSK



D5484-041 AFT CAP ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE PER QSI 005.4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 8.1
 - 7) WEIGHT: 0.29 LBS
 - 8) IT IS ACCEPTABLE TO USE LONGER OR SHORTER CCR264SS-3 RIVETS TO INSTALL THE MS21075L3N NUTPLATE REF: AC43-13-1B CHAPTER 4
 - 9) MASK PRIOR TO FINISHING

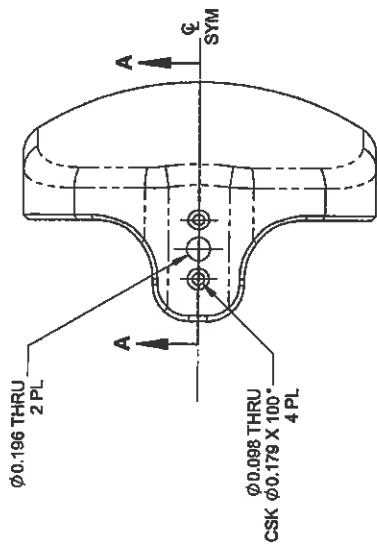
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DATE		17.02.14		BY		DATE		17.02.14	
DESCRIPTION		NO		BY		DATE		17.02.14	
DART AEROSPACE USA, INC.		NO		BY		DATE		17.02.14	
EUGENE, OR		NO		BY		DATE		17.02.14	
DRAWING NO.		NO		BY		DATE		17.02.14	
D5484		NO		BY		DATE		17.02.14	
TITLE		NO		BY		DATE		17.02.14	
AFT CAP		NO		BY		DATE		17.02.14	
SCALE		NO		BY		DATE		17.02.14	
NTS		NO		BY		DATE		17.02.14	
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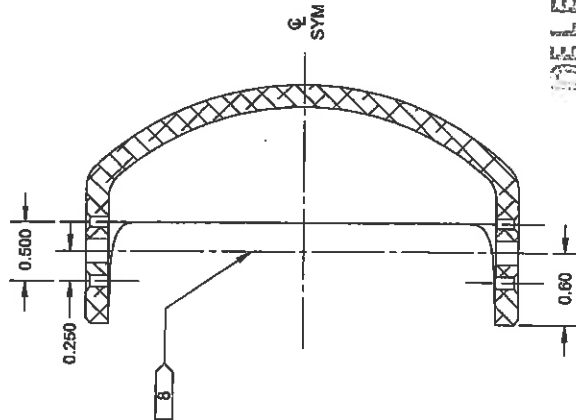
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2017-10-31

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D5484-1
(DRILLING DETAIL)



SECTION A-A

- NOTES:
- 1) MATERIAL: MAKE FROM D5484-1C
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) Ø0.196 HOLES TO BE ALIGNED WITHIN ±0.005 OF EACH OTHER AS SHOWN (2 PL)

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2017-10-31

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MFG. APPR.	JFS	D5484	SHEET 2 OF 3
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DATE	17.02.14		

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